

5/26

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23557
<b>Description:</b> 206 A/B High Gear Web		<b>Part Number:</b>	D2654-3
05.01.13 E1 05.01.13			
<b>Drawing:</b> D2654 Rev. 2 DEO 9136		<b>Qty:</b>	1

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	DP	05.06.14	1
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-5 Web 12433	DP	05-8-22	1
3	METAL	Cut D2600-5 to length as per Dwg D2654	DP	05-8-22	1
4	METAL	Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654	PMC	05-8-29	1
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	PMC	05-8-29	1
6	METAL	Deburr holes and ends	PMC	05-8-29	1
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	PMC	05-8-29	1
8	QC	Inspect Level 5	Jac	05-08-30	1
9	METAL	Identify and stock	PMC	05-8-30	1
10	EXPEDITING	Close Work Order Inspect level 21 Cost/part: 47.91 5 uic 05/08/07 (1)	DP	05-08-30	1

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	02-05-27

RELEASED

02/05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 25/08/30

NOTE: Date & initial all entries

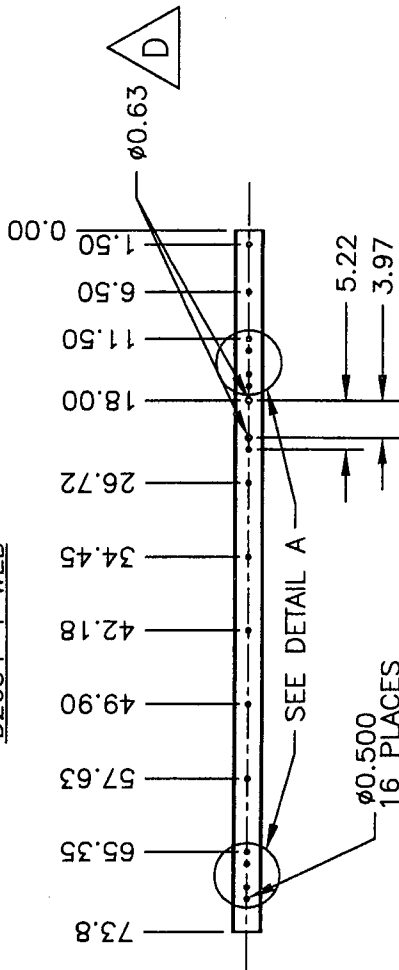
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



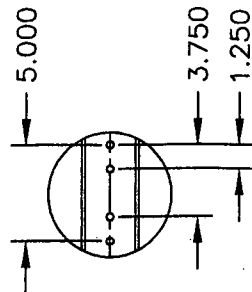
DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2654	REV. E  SHEET 1 OF 2
DATE 04.05.26				TITLE WEB	SCALE  1:20
A	97.03.25			NEW ISSUE	
B	97.06.26			ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29			CHANGED HOLE PATTERN	
D	98.01.15			GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26			CHANGE LENGTHS, REFORMAT	
E1	 04.08.04			PER TOOLING; 80.8 WAS 80.5	

RELEASED  
04.06.22

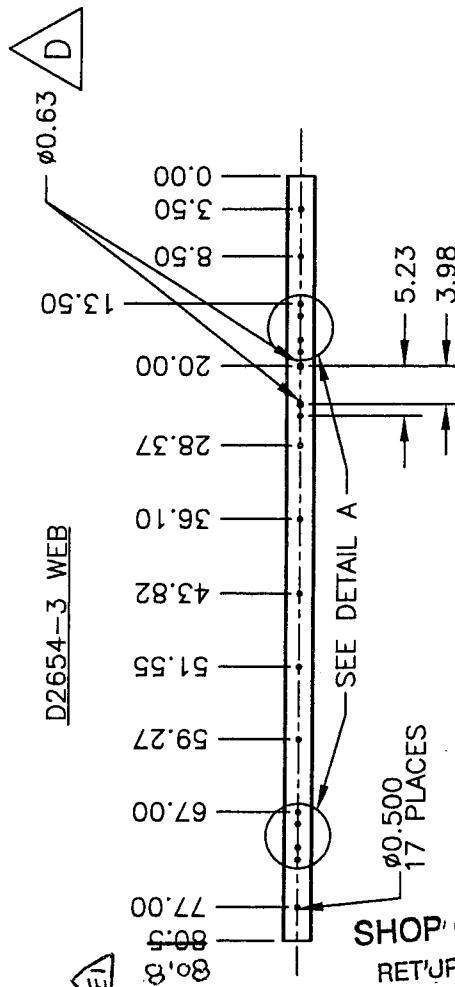
D2654-1 WEB



DETAIL A  
SCALE 1:10



D2654-3 WEB



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WITHOUT NOTICE

WORK ORDER  
NO. 23551

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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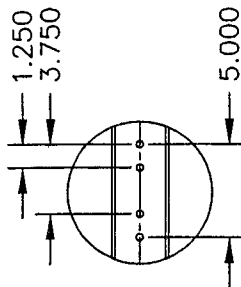
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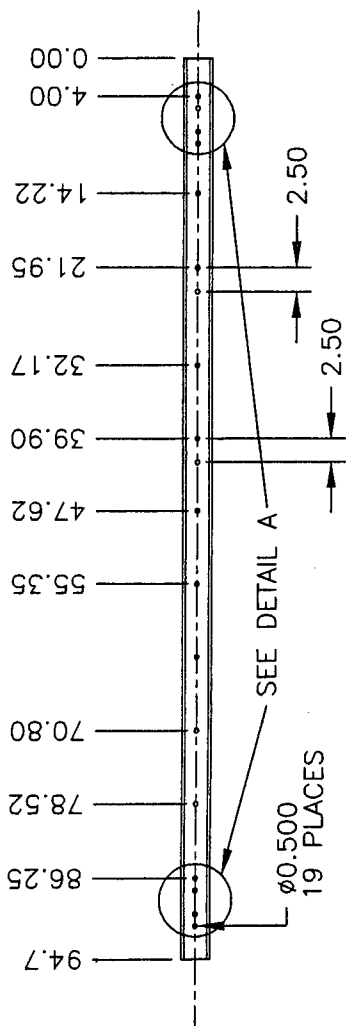
DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26	TITLE WEB	SCALE 1:20	

RELEASED  
04.06.22

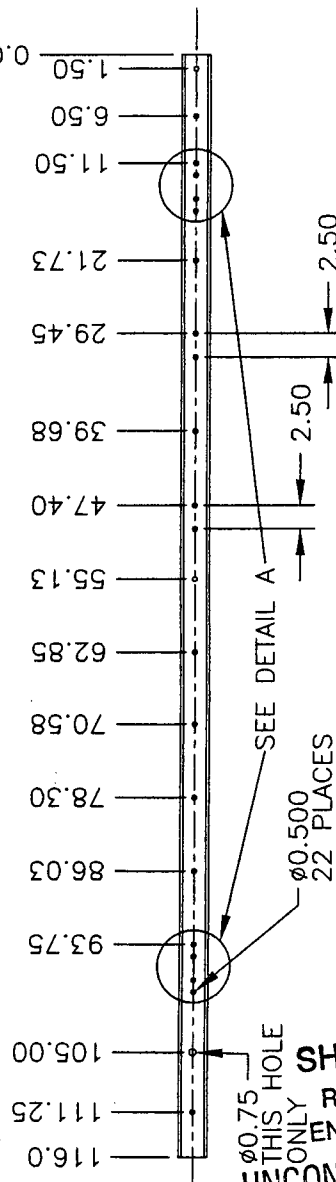
DETAIL A  
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



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WORK ORDER  
NO. 23557

MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DM	APPROVED KE	DRAWING NO. DEO 9136	REV. A SHEET 1 OF 1
DATE 99.02.26	TITLE 206 SKIDTUBE WEB LENGTH CHANGE		SCALE NTS
A	99.02.26	NEW ISSUE	

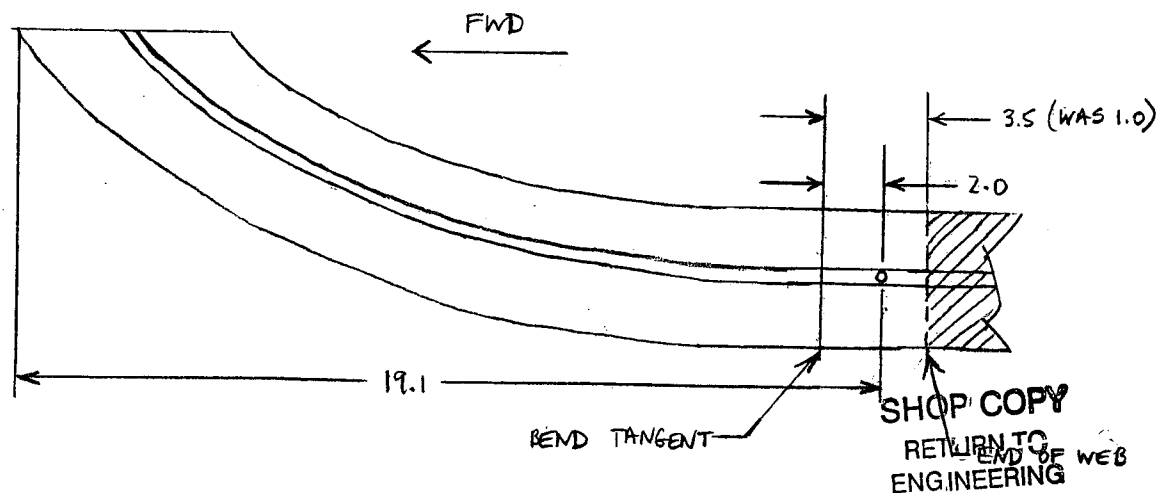
## DART ENGINEERING ORDER

TO AMEND DWGS: D2650 REV. C  
D2654 REV. D

TO FACILITATE BENDING D206-642 SKIDTUBES IN-HOUSE, ALL WEBS CALLED UP ON DWG D2654 SHOULD BE SHORTENED BY 2.50" AT THE FWD END. THIS WILL ELIMINATE THE NEED TO DRILL THE FWD HOLE ON ALL WEBS SHOWN ON DWG D2654. THE REVISED LENGTHS ARE AS FOLLOWS:

PART NO.	LENGTH WAS	LENGTH NOW
D2654-1	76.35	73.85
D2654-3	83.35	80.85
D2654-5	97.25	94.75
D2654-7	118.50	116.00

THE BENDING DETAIL ON PAGE 7 OF DWG. D2650 WILL NOW BE AS FOLLOWS:



IT IS ACCEPTABLE TO ENGINEERING TO HAVE A MAXIMUM REDUCTION IN DIAMETER OF 0.150" FWD OF THE WEB IN THE BENT PORTION OF THE TUBE. SUBJECT TO AMENDMENT WITHOUT NOTICE

**RELEASED**  
99.03.02 DS

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**WORK ORDER**  
**NO. 23557**

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 10, 2005  
01:45 pm

Work Order No : 0023557  
Project Name : D2654-3  
Project For : WK526  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2654-3  
Description : 206 I-Beam (Web)  
Manufactured : Yes  
Amount Req'd : 1  
Amount Done : 0  
Start Date : 06-10-05  
Est Finish Date : 06-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00